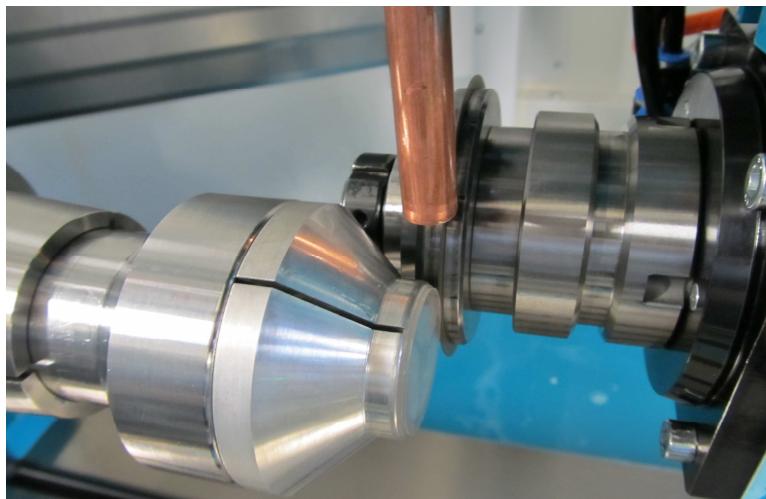
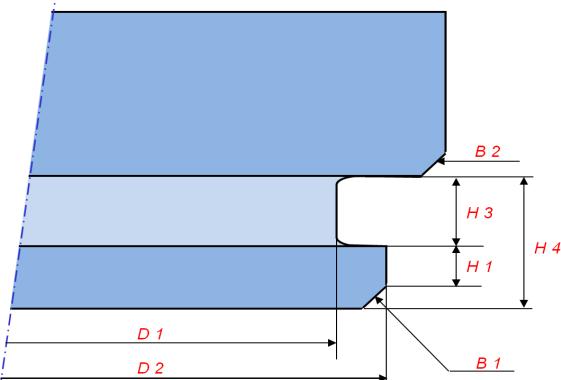


## SaphirGlas-Scheibe Ø28.5

A20-900

Schrupp-Rundschleifen mit 30 rpm und Zustellung von 0.02 mm pro Umdrehung, Schlichten mit 100 rpm und 0.002 Zustellung pro Umdrehung.



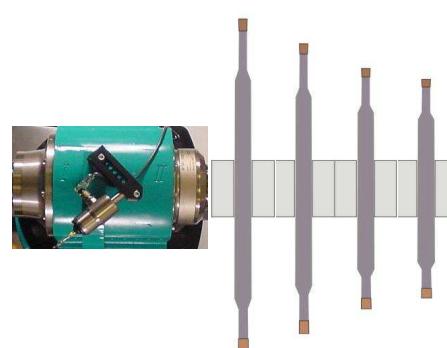
### 1. Cycletime for Production

Workpiece:	Ø28.5/Ø28.0/Ø29.46 mm, H4= 0.87 Material SAPPHIRE					
Operations	Vorschl. H3	Vorschl. H1	Fase B1	Fase B2	finish H3	finish H1
Feed [rpm]	30	30	30	30	100	100
Power [kW]	1	1	1	1	1	1
Cutting speed [m/s]	24	24	24	24	24	24
Used wheels	1	2	3	3	4	3
Grinding time [s]	110	70	30	30	37	37
Total cycle time	5 Min 14					

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

### 2. Used Grinding Wheels

1	14A1 Ø175 D46
2	14A1 Ø125 D46
3	14A1 Ø150 D30
4	14A1 Ø200 D30



4 1 3 2

### 3. Machine and Software Requirements

Machines:	5 axes CNC grinders : GEMINI DMR	Coolant:	pressure 6 bar
Control:	Fanuc 31i	Software:	Quinto 5
Accessories:	AWL		
Responsible engineer:	OP. 2.5.11		

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